

Work Order ID 108100

November-22-13 8:50:47 AM

108100

Page 1

Item ID: D3213-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Interior Door For -015 & -025
 Start Date: 10/07/13 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 10/07/13 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MUS Date: 13-10-07 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3213	B ✓

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab 1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520

Identify as D3213-041

110 QC5- Inspect part completeness to step on W/O 0.00

110
 QC Memo 0.00
 Quality Control

120 Black Sandtex(Ref 4.3) QSI005 4.3 0.00

120
 Powdercoat Memo 0.00

Powder Coating
 START TIME: 3:45 OVEN TEMPERATURE:
 FINISH TIME: 4:15

DAS
36
9-89

13/11/25

SMP
13/11/25

Sx

S

DAS
34
9-89

5 13-11-07

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Item ID: D3213-041 Accept *N900040100* Setup Start *NS1*
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				5x			13/11/28	DAS 36 9-89
140 *140* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3213	0.00 0.00				5x			13/11/28	DAS 36 9-89
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				S			13/11/28	DAS 27 9-89

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Item ID: D3213-041 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 10/07/13 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 10/07/13 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>85211</i>	0.00							
160									
Packaging	Memo	0.00				<i>5x</i>		<i>13-11-28</i>	
Packaging									
									DAS 26 9-89
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

13/12/02
13/11/29
mk
13-11-29

Picklist Print

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Work Order ID: 108100

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Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3 *D3161-3* Hinge		Manufactured	No			100	Each	9.0000	2	10	**	13/11/22	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST031				9					
					108421			9		10			DAS 36 9-89
D3213-1 *D3213-1* Door Panel		Manufactured	No			100	Each	12.0000	1	5	**	13/11/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232				12					
					102995			12		5			DAS 36 9-89
D3213-3 *D3213-3* Door Panel		Manufactured	No			100	Each	15.0000	1	5	**	13/11/22	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232				15					
					102770			10		2			
					68907			2					
					74539			1					
					98288			2		3			

Picklist Print

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Work Order ID: 108100

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Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 5.00

Required Qty: 5.00

MS20470AD4-6

Purchased

No

100

Each

2,132.000

1

5

MS20470AD4-6

RIVET

**

13/11/28

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

3

118927

3

ST306

1971

m127305

1971

ST336

127

125654

127

ST505

31

123021

31

D2137

Manufactured

No

140

Each

23.0000

1

5

D2137

Decal(No Step)

**

13/11/28

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

23

108061

17

90854

6

D2419

Manufactured

No

140

Each

3.0000

1

5

D2419

Handle

**

13/11/28

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

3

108447

3

B109503
52

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Shop Packet Print

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Picklist Print

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Parent Item: D3213-041

D3213-041

Parent Item Name: Replacement Interior Door For -015 & -025

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 5.00

Required Qty: 5.00

D2462 Manufactured No

140 f

353.0662 2.4 12

D2462

Seal \$Per Foot

**

13/11/28

DAS
36
9-89

Location

Loc Qty

Loc Code

ST402

353.0662

48530

13.7336

98802

339.3326

12

MS20470AD4-4

Purchased No

140 Each

2,676.000 24 120

MS20470AD4-4

Rivet, Universal Head

**

13/11/22

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

2675

116188

68

118614

135

122027

188

m125807

78

m126275

2206

120

NAS1149DN632J

Purchased No

140 Each

487.0000 1 5

NAS1149DN632.J

Washer

**

13/11/28

DAS
36
9-89

Location

Loc Qty

Loc Code

ST293

476

123900

5

M126084

365

M126254

6

M127255

100

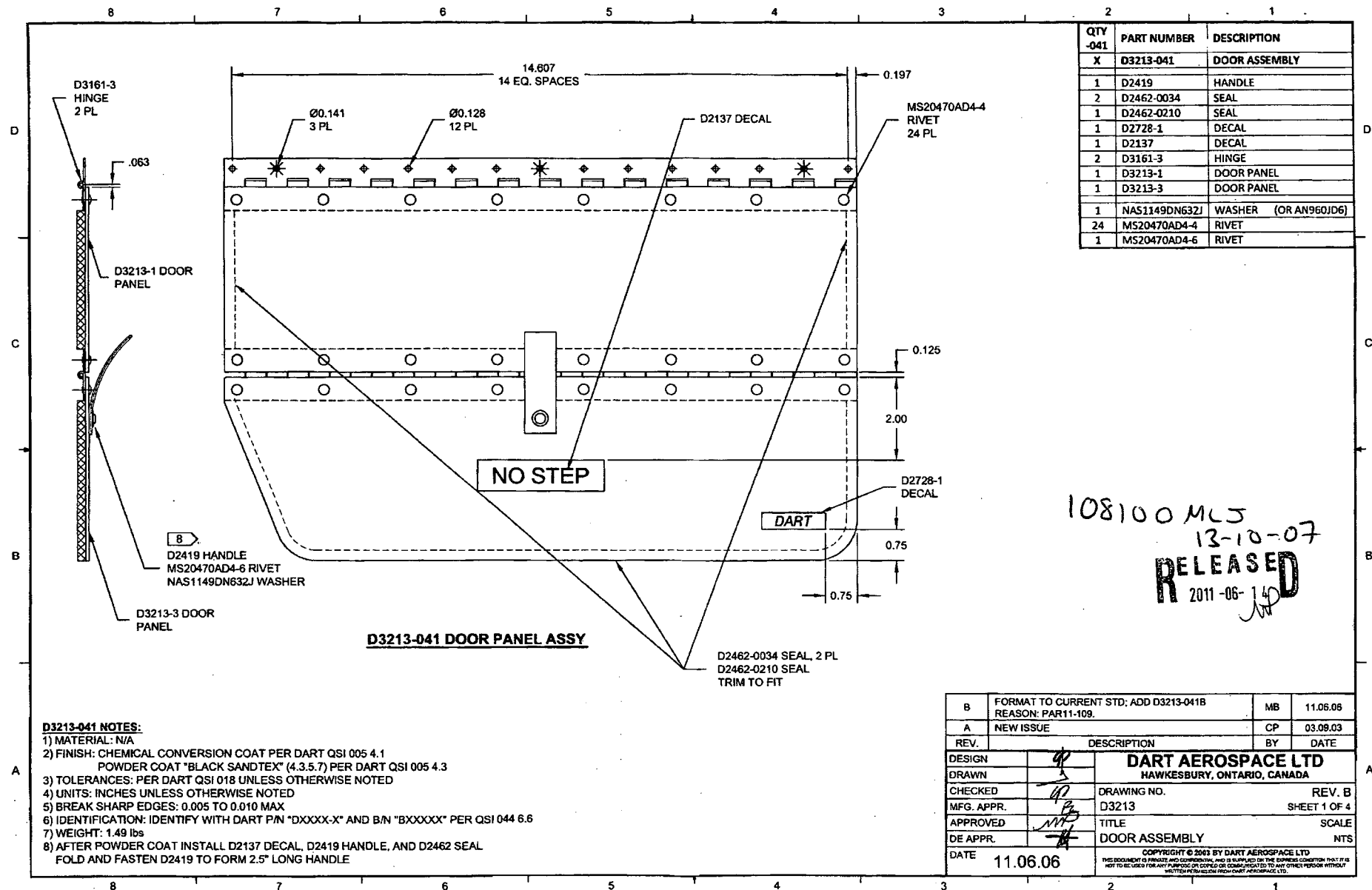
ST510a

11

125646

11

5

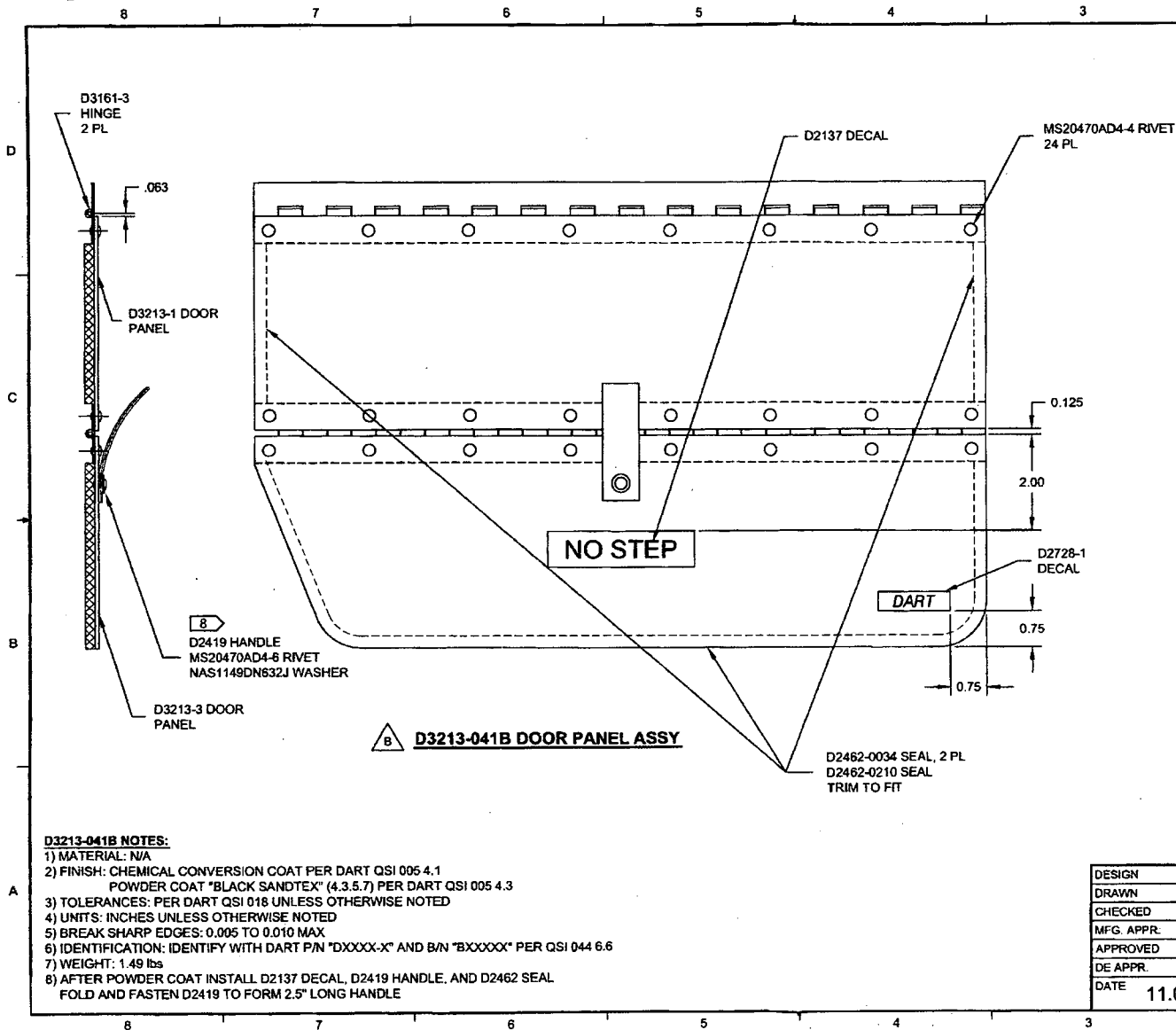


QTY	PART NUMBER	DESCRIPTION
X	D3213-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

B	FORMAT TO CURRENT STD: ADD D3213-041B	MB	11.06.06
A	REASON: PAR11-109.	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3213	REV. B SHEET 1 OF 4
TITLE DOOR ASSEMBLY	SCALE NTS
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108100



QTY -041B	PART NUMBER	DESCRIPTION
X	D3213-041B	DOOR ASSEMBLY, BLANK
1	D2419	HANDLE
2	D2462-0034	SEAL
1	D2462-0210	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
2	D3161-3	HINGE
1	D3213-1	DOOR PANEL
1	D3213-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
24	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

B D3213-041B DOOR PANEL ASSY

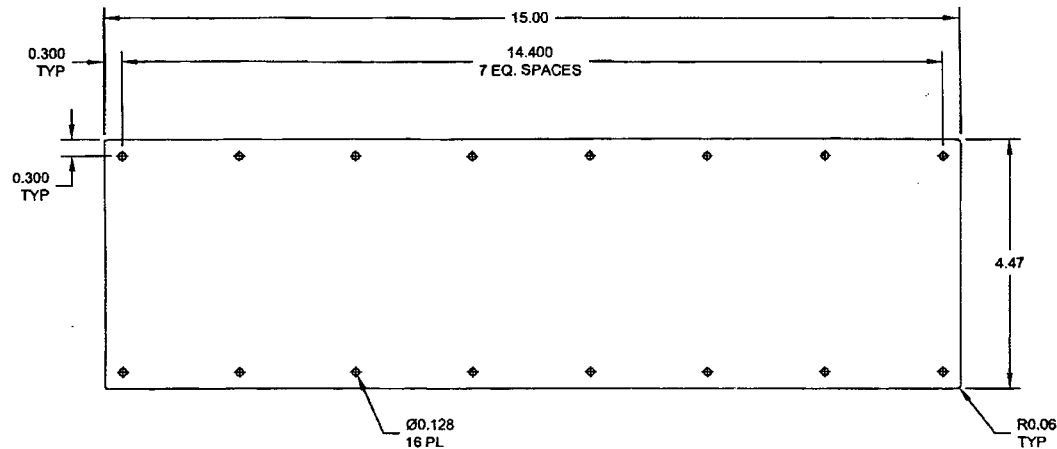
RELEASED
2011-06-14
AM

D3213-041B NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.6
- 7) WEIGHT: 1.49 lbs
- 8) AFTER POWDER COAT INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

DESIGN	4P	DART AEROSPACE LTD	
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CHECKED	TP	DRAWING NO. D3213	REV. B
MFG. APPR.	TP		SHEET 2 OF 4
APPROVED	TP	TITLE DOOR ASSEMBLY	SCALE
DE APPR.	TP		NTS
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108100



D3213-1 DOOR PANEL

RELEASED
2011-06-15

D3213-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.42 lbs

DESIGN	9P	DART AEROSPACE LTD	
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CHECKED	7	DRAWING NO.	REV. B
MFG. APPR.	7	D3213	SHEET 3 OF 4
APPROVED	7	TITLE	SCALE
DE APPR.	7	DOOR ASSEMBLY	NTS
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Technical drawing of a rectangular plate with the following dimensions and specifications:

- Overall width: 15.00
- Overall height: 4.42
- Distance from left edge to centerline: 7.500
- Distance from centerline to right edge: 7.500
- Distance from left edge to first hole: 0.300
- Distance between holes: 14.400 (7 EQ. SPACES)
- Hole diameter: $\varnothing 0.128$
- Hole quantity: 9 PL
- Radius of bottom corners: R1.00 (3 PL)
- Radius of top corners: R0.06 TYP
- Thickness of plate: 0.300 TYP
- Other dimensions: 0.59, 1.00

RELEASED
2011-06-10

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T35.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.39 lbs

DESIGN	<i>4</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3213 TITLE DOOR ASSEMBLY COPYRIGHT © 2003 BY DART AEROSPACE LTD. THIS DOCUMENT IS PREPARED BY DART AEROSPACE LTD. FOR THE EXCLUSIVE USE OF THE CUSTOMER. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	REV. #
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APPROVED	<i>[Signature]</i>		SCALE
DE APPR.	<i>[Signature]</i>		NT
DATE 11.06.06			